

Date: Monday, 16/03/2009 2:01:43 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
Job Number : 46527
Estimate Number : 10759
P.O. Number :
This Issue : 16/03/2009 S.O. No. :
Prsht Rev. : NC Part Number : D34623
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3462 REV C
Previous Run : 46267 Project Number : N/A
Material :
Due Date : 30/03/2009 Qty: 10 Um: Each
Written By :
Checked & Approved By : JULIA 0310
Comment : EST REV. A 05.11.18 NEW ISSUE EC
Est Rev:B Now on Waterjet 06-06-16 JLM
esr rev C 08.07.15 ecn 1049 EC verified by: DD
Est Rev: D 09.03.10 Added steps 5-6 per B45184 Verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304B0375X03000 M304 SS bar .375 x 3.00



Comment: Qty.: 0.2793 f(s)/Unit Total : 2.7930 f(s) (3.9102 x 14)
M304 SS 3/8"X3" 11369 B9-4-14
(M304B0375X0300)
Batch: 107513 ml 09 04 02

(10)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3462
Dwg Rev: C
Prog Rev: C

B9-4-14

(16)

2-Deburr if necessary

ml 09 04 02

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B9-4-14 ml 09 04 02

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/04/14 (16)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3462-3 PAR #: N/A Fault Category: Prod Line assembly med & Small NCR: (Yes) No DQA: A Date: 08/04/20
D3462-041/042 D412-630-031
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: N Date: 09/04/20

NCR: <u>46527</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/2	# 20	During inspection one part Found with cutout from water Jet inside the 0.257" hole. Also Found on all	<u>CP</u> 09.04.02 p1 08/04/2	SCRAP PARTS with oversized holes qty <u>(x10)</u> Replace	<u>B</u> 9-4-14	<u>S</u> 09/04/14	<u>CP</u> 09.04.02 p1 08/04/2	<u>S</u> 9/4/2
		Parts that the 0.257" holes larger from .257" to .268" has a taper from water jet EC:		M304SS 3/8" x 3" M# <u>111369</u> <u>(N6)</u>	<u>B</u> 9-4-14	<u>S</u> 09/04/14		

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 2:01:43 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46527

Part Number: D34623

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



16X

Comment: SMALL & MEDIUM FAB RESOURCE 1
Chamfer 0.08" on 45° as per dwg

M-1 09/04/16

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/16 (16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Carl

SS 09/04/17 (17)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/22 (22)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

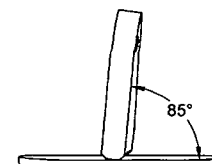
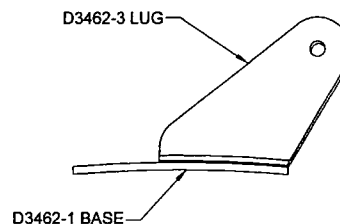
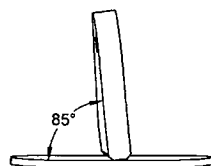
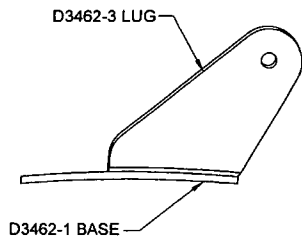
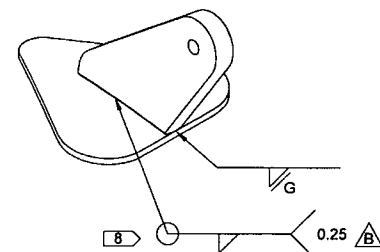
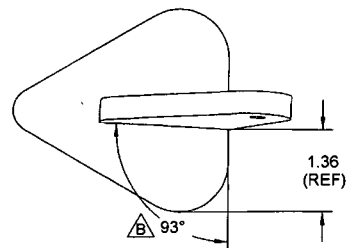
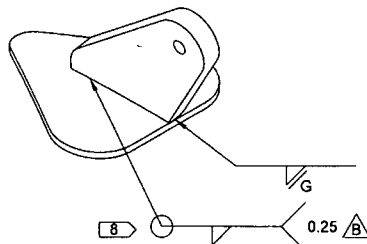
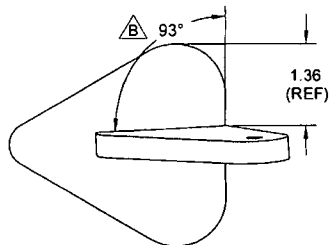
☒ **First Article** ☐ **Prototype**

[illegible]

All parts were
 scanned
 6/4/2

Measured by:	<i>m. m</i>	Audited by:		Prototype Approval:	N/A
Date:	<i>09.04.02</i>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.27	New Issue	KJ/JLM	
B	08.07.24	Dwg Rev updated	KJ/DD	



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

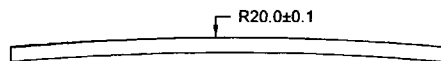
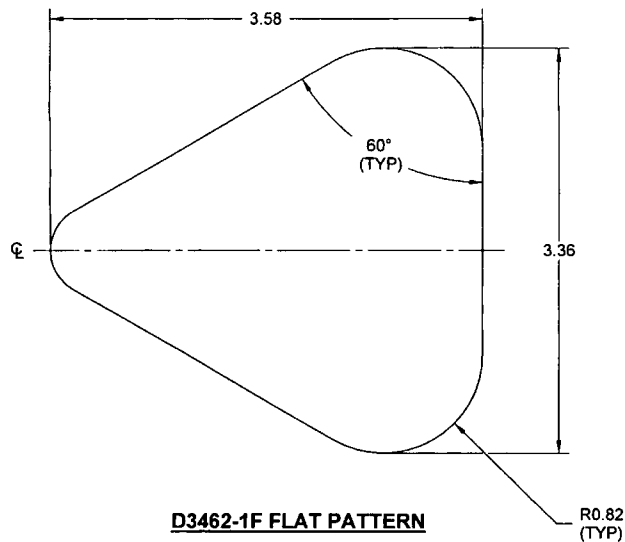
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

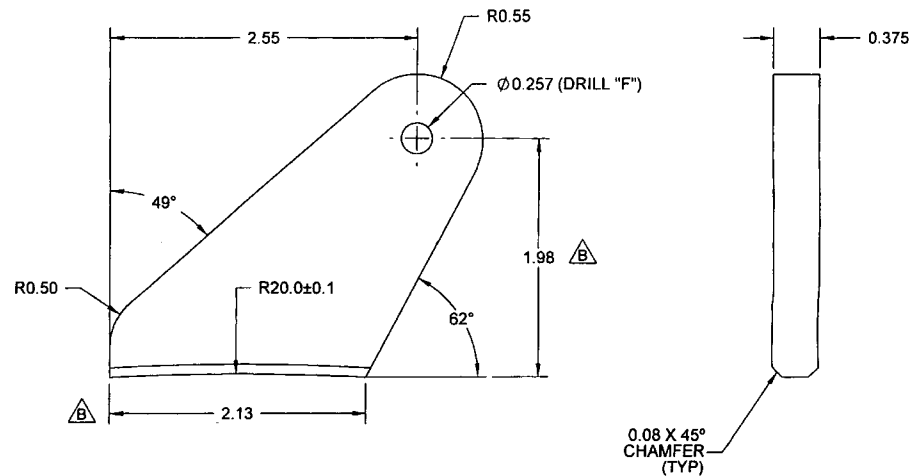
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

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C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	V.P. D.C.		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 TITLE BRACKET ASSEMBLY SCALE 1:2 REV. C SHEET 1 OF 2 COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			









- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:**
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
8.07.07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3462	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	
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